

Date: Thursday, 7/19/2007 2:28:07 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE BILLET (6061)
Job Number	: 33681		
Estimate Number	: 12482		
P.O. Number	: <i>N/A</i>	Part Number	: D6102013
This Issue	: 7/19/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D6102 REV D
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 28811	Drawing Revision	: D
		Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 8/15/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	60 Um: Each
Comment	: Est Rev: A New Issue 06-07-03 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING

Comment: Issue P/O: *4230*

a) Description: Aluminum Billet

b) 7.000" x 6.500" x 2.000" thick

c) Tolerance on all dimensions is +0.06/0.00

d) Grain direction along 6.500" length

e) Material: 6061-T6/T6511 (QQ-A-250/11 or QQ-A-200/8)

Material release certificate is required

*C/L 07/07/20*  
*(60)*

2.0

D6102013P

6061-T6 7.0x6.5x2.0



Comment: Qty.: 1.0000 Each(s)/Unit Total : 60.0000 Each(s)  
 6061-T6 6.0x11.0x5.0

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

*7/18/07 SP* *60 SP*

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Check certification to Dwg D6102 for compliance

*7/18/07 SP* *60 SP*

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*C/L 7/18/07 60*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 07/08/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 7/19/2007 2:28:07 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET (6061)

Job Number: 33681

Part Number: D6102013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



60

Comment: FINAL INSPECTION/W/O RELEASE

D 07/08/10

Job Completion



CZ 07/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

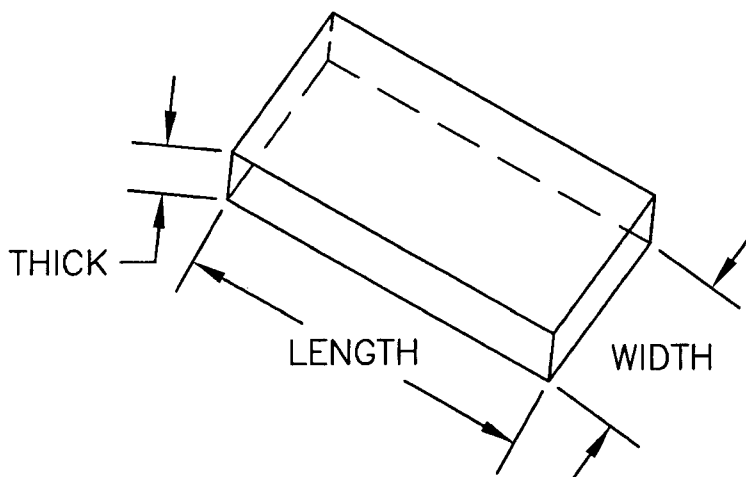
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D6102	Rev. D SHEET 1 OF 1
DATE 06.06.30		TITLE SADDLE BILLET, 6061	SCALE NTS
A	01.03.30	NEW ISSUE	
B	03.10.20	ADD D6102-005/-007/-009	
C	04.08.25	ADD D6102-010/-011	
D	06.06.30	ADD D6102-013	

## SPECIFICATION CONTROL DRAWING



RELEASED

06.08.15 #

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.06/-0.00), AND GRAIN DIRECTION AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.06/-0.00.

ALL DIMENSIONS ARE IN INCHES.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6102-001	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.880	6.250	2.000	Along 7.880 Length
D6102-003	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.000	6.250	2.000	Along 6.000 Length
D6102-005	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	47.85	15.250	1.000	Along 47.85 Length
D6102-007	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.500	7.000	2.500	Along 7.500 Length
D6102-009	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	11.000	6.000	5.000	Along 11.000 Length
D6102-010	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.950	8.250	2.500	Along 7.950 Length
D6102-011	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.500	8.250	2.500	Along 6.500 Length
D6102-013	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.500	7.000	2.000	Along 6.500 Length

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# DART

## Purchase Order

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7  
Phone: (613)632-9577  
Fax: (613)632-1053

Date Jul 20, 2007	Page 1
Purchase Order Number PO00004230	

**FAXED**  
63676720

**Vendor Address:**

Metaux - Castle  
A.M. Castle & Co. (Canada) Inc. - Box B9204  
P.O. Bo: 9100  
Toronto, ON M4Y 3A5  
Phone (514) 694-9575  
Fax (514) 695-3281

**Ship To:**

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-MET001	Jul 20, 2007	N30	PREPAID	Aug 03, 2007

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
60.0000	D6102013P	6061-T6 7.0x6.5x2.0 Comments: ALUMINUM BILLET 7.000" X 6.500" X 2.000" THICK TOLERANCE ON ALL DIMENSION IS +0.06/0.00 GRAIN DIRECTION ALONG 6.500" LENGTH MATERIAL: 6061-T6/T6511 (QQ-A-250/11 OR QQ-A-200/8) AS PER DWG 6102 REV. D	8/3/2007	No	36.750000	Each	2,205.00
40.0000	D6101001P	7075-T7351 2X6X6.25 Comments: ALUMINUM BILLET 6.00" X 6.250" X 2.00" THICK TOLERANCE ON LENGTH ARE +0.030/-0.000 GRAIN DIRECTION ALONG 6.00" LENGTH MATERIAL: 7075-T7351 (QQ-A-250/12)	8/3/2007	No	68.400000	Each	2,736.00
6.0000	D6102005P	Billet 1X15.25X48" Comments: ALUMINUM BILLET 47.85" X 15.25" X 1.0" THICK TOLERANCE ON ALL DIMENSIONS ARE +0.006"/-0.000" GRAIN DIRECTION ALONG 47.85" LENGTH MATERIAL: 6061-T6/T651 (QQ-A-200/8) AS PER DWG D6102 REV. D	8/3/2007	No	289.000000	Each	1,734.00

**Comments**

**MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY**

**Tax Summary:**

GST 400.50  
GSTME 0.00  
GSTND 0.00

**Less:**  
included tax

0.00

**Subtotal**

6,675.00

**Total tax**

400.50

**Total purchase order in**

Entered By: *CLAVOIE*

Approved By: *11*

The logo for DART Aerospace Ltd, featuring the word "DART" in a bold, italicized, sans-serif font inside a black rectangular box.

**DART AEROSPACE LTD**  
1270 Aberdeen Street  
Hawkesbury, ON, K6A 1K7  
CANADA

**Tel: 613 632 9577**  
**Fax: 613 632 1053**

**E-Mail: [lindal@dartaero.com](mailto:lindal@dartaero.com)**  
**[www.dartaero.com](http://www.dartaero.com)**

## **TELEFAX**

**Date:** July 20, 2007  
**To:** Metaux Castle  
**Attention:** Marc Desbien  
**Fax Number:** 514-695-3281  
**From:** **Chantal Lavoie**  
**E-mail:** [clavoie@dartaero.com](mailto:clavoie@dartaero.com)

**Subject:** \_\_\_\_\_

Please advise price & delivery on material below.

D6101-001 material: 7075-T7351 ( QQ-A-250/12 ) 6.00 length x 6.25 width x 2" thick grain direction 6.000 length. X 40

D6102-005 material: 6061-t6/t651 (QQ-A-250/11 OR QQ-A-200/8) 47.85 length x 15.25 width x 1.00" thick grain direction along 47.85 length. X 6

D6102-013 material: 6061-t6/t651 (QQ-A-250/11 OR QQ-A-200/8) 6.500 length x 7.000 width x 2.00 thick grain direction along 6.500 length. X 60

Thanks  
Chantal

T. (NO. CLIENT) 554602 973340 01 REQUISITION CLIENT-CUSTOMER REQUISITION NO.		NO. COM. CLIENT-CUST. ORD. NO. 4230		COMPTES-RENDUS 91037 230 40 TRACK		EXPEDIE PAR SHIP VIA MANITOULID		EXPEDIE 08 AOÛT 2007	
ACHETEUR-PURCHASING AGENT LINDA LACELLE		TELEPHONE 618 632-3336		HC 9 2 1		REGION LIVRAISON-DEL. ZONE C/C		PREPAID	
RÉ-ACHETER:		VENDU À-OLD TO: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY ON K5A 1K7		INFORMATION CREDIT-CREDIT INFORMATION		ROUTE 01*NL-08/21 31-NL-08/21			
INSTRUCTIONS LIVRAISON-DELIVERY 700-558568		INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT.)		INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT.)		INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT.)			
DESCRIPTION - ITEM 1 2.0000 PLATE 6061-T651 ALUM 7.00" X 6.50" BLUE		INSTRUCTIONS TOL: +.030"/-.000" THICKNESS TOL: +.030"/-.000" GRAIN TO RUN ALONG 6.50" PRIOR DIST/3RD: 01 973340		COULÉE INFO-HEAT INFO QTE-QTY 05/06/38563		QUANTITÉ COM. ORDERED 48 PCS PCS BALLOTS-BUNDLES 1 60 543 POIDS COM. WT. ORDERED 543 POIDS EXP. WT. SHIPPED 543 FORME-SHAPE I.A.C. B641		23.640500	
CERTIFICAT DE CONFORMITÉ A.M. Castle & Co. (Canada) Inc. certifie que le matériel fourni d'après ce document répondra et est conforme aux spécifications du produit(s) décrit(s) ci-dessus. A.M. Castle & Co. (Canada) Inc.		POIDS POUR EXPÉDITION SEULEMENT. VOIR FRACTURE POUR LE POID EXACT FRACTURE. SVP SIGNER ET DATER LA COPIE DU CHAUFFEUR POUR RÉCEPTION DU MATÉRIEL, SI VÉRIFIÉ CERTIFICAT D'ANALYSE.		INSTRUCTIONS (CONT'D.) 60x6.5x7.00		INSTRUCTIONS (CONT'D.)			
DESCRIPTION - ITEM 2 TERMES ET CONDITIONS DE VENTES DESAVEU DES GARANTIES ET RESTRICTION DE RESPONSABILITÉ AU VERSO		INSTRUCTIONS 1 Box		COULÉE INFO-HEAT INFO QTE-QTY		QUANTITÉ COM. ORDERED BALLOTS-BUNDLES POIDS COM. WT. ORDERED POIDS EXP. WT. SHIPPED FORME-SHAPE I.A.C.			
DESCRIPTION - ITEM 3 TOUTES DIFFÉRENCES OU DOMMAGES DOIVENT ÊTRE INDICUÉS SUR LA COPIE REÇUE LIVRAISON ET LA REVÊTE D'EMBALLAGE ET SIGNÉ PAR LE CHAUFFEUR ET LE CLIENT. UNE COPIE DE CE REÇU DOIVRA ÊTRE SOUSCRITE DANS LES 10 JOURS SUIVANT LA LIVRAISON.		INSTRUCTIONS		COULÉE INFO-HEAT INFO QTE-QTY		QUANTITÉ COM. ORDERED BALLOTS-BUNDLES POIDS COM. WT. ORDERED POIDS EXP. WT. SHIPPED FORME-SHAPE I.A.C.			

10-08-07 07:53 FROM-metalex castle

514-695-3281

10-08-07 07:53 FROM-metalex castle



03-29-'07 10:11 FROM-

T-956 P003/010 F-566

# TEST CERTIFICATE



BUYER: EMERSON REFRIGERATE INC ONE HANOVER PLAZA 10TH FLOOR PORT LEE, NJ 08064		Selling Product: LBR100-30 Lot No: D00100000 Plant No: 2010000 Reference No: Order No: (3807)E Material Order No: (3807)E Unit No: 1/1		Product: Description: Alloy - Temp: Condition: 2" x 48" x 144" 3001-1001 Order No: 070100000 Order Part No: Order Part No:	
Case No: 01-8404-7					

MECHANICAL TEST RESULTS									
Lot No.	Prod No.	Alloy	Spec No	Mechanical Properties					
				Tensile Strength (ksi)	UTS (ksi)	Yield Strength (ksi)	Elongation (%)	Reduction of Area (%)	Charpy Impact (ft-lb)
0000			1010	85.1	42.1	90.0			
00000000	P150	0001	1	40.7	45.2	41.2			3801007
			2	40.7	45.2	41.2			2801007

CASTLE METALS CORP  
DATE RCVD 3-28-07  
IAC 8/1/1  
APPROVED BY *[Signature]*

CHEMICAL COMPOSITION									
Lot No.	Prod No.	Alloy	Si (%)	P (%)	S (%)	Mn (%)	Fe (%)	C (%)	N (%)
0000			0.420	0.150		0.420	0.420	0.420	0.420
	P150	0001	0.420	0.150	0.420	0.420	0.420	0.420	0.420
			0.420	0.150	0.420	0.420	0.420	0.420	0.420

Approved by: *[Signature]* (303) 695-3281, 10000 S. 10th Ave. Suite 100, Aurora, CO 80015-1000, USA  
We hereby certify that the material described herein was tested and compared with the testing of the order contract. The results are as follows:  
The results of the chemical composition tests are within the limits specified in the contract.

IN A REMARKS OF CHEMICAL TESTS

IN A REMARKS OF CHEMICAL TESTS

Print Date: 10/08/07 10:11

Print Date: 10/08/07 10:11